Bate:

Wednesday, 10/06/2009 10:34:05 AM

User: Julie Dawson

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Job Number : 48453 **Estimate Number** : 10866

P.O. Number

: 10/06/2009 This Issue

Prsht Rev. : NC

First Issue : //

: 45504 Previous Run

Written By

Checked & Approved By Comment

: Est A 03.01.29

Type : PURCHASED PARTS

New issue KJ/RF

Project Number Drawing Revision

Material

Drawing Name

Part Number

Drawing Number

Due Date : 16/06/2009

Qty:

: HINGE

: D31821

: N/A

: D3182 REV A

4 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

304/316 0.125 Sheet

M304S11GA 1.0

Comment: Qty.:

0.0626 sf(s)/Unit

Total:

0.2503 sf(s)

304/316 .125 Sheet Batch: 111 618

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3182 Dwg Rev: A

Prog Rev: /

B 9-6-11

2-Deburr if necessary

3.0

QC2

189-6-11

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

Page 1

Form: rprocess

Dail Ac	ospuoc Eta									
W/O:			WORK ORDER CHANGES							
DATE STEP		ŗ	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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								1		
			· · · · · · · · · · · · · · · · · · ·		<u></u> .,					
Part No		PAR #:	Fault Category:	NCR: Yes	No DQ	A:	Date: _	 		
	Resolu	ution:	Disposition:	QA: N/C (Closed:		Date: _			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
D.4.T.F	0===	Description of NC		Corrective Action Section B			Ammunual			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector		

Date: Wednesday, 10/06/2009 10:34:05 AM User: Julie Dawson **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: HINGE Job Number: 48453 Part Number: D31821 Job Number: Seq. #: **Machine Or Operation:** Description: INSPECT WORK TO CURRENT STEP QC5 6.0 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 7.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 8.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

W/O:		WORK ORDER CHANGES										
DATE STEP		PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
												
		•										
	<u> </u>						<u> </u>					
Part No					NCR: Yes No DQA: Date:							
Resol		· · · · · · · · · · · · · · · · · · ·		QA: N/C Closed: Date:								
NCR:		,	WORK ORDE	R NON-CONFORM	ANCE (NCR)	•		-			
DATE	STEP	Description of NC						Approval	Approval			
	J.E.	Section A	Initial Chief Eng	Action Description Chief Eng	otion Sign & Date		ion C	Chief Eng	QC Inspector			

DART AEROSPACE LTD	Work Order:	48453
Description: Hinge	Part Number:	D3182-1
Inspection Dwg: D3182 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST										
		X First Art	icle	Prot	otŷpe					
Drawing* Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments			
3.718	+/-0.010	3770	2							
Ø0.257	+0.006/-0.001	,259	*							
2.304	+/-0.010	2.313	>							
R0.125	+/-0.010	361,	×							
Measured by:	1B	Audited by:			Prototype	Approval:	N/A			
Date:	76-11	Date	09/64	14		Date:	N/A			
Rev Date	Change					vised by	Approved			
A 06.10.12 B 08.01.16		8	MT-			/JLM /EC/DD ∰	17/2			

W/O:		WORK ORDER CHANGES									
DATE	STEP		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Dart No		DAD #			_		1				

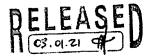
Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:	Disposition:	OA: N/C Closed:	Data

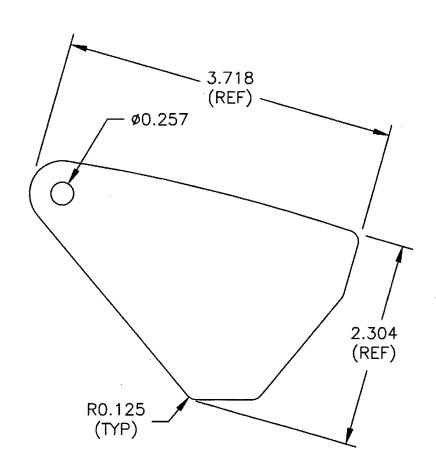
NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE	0750	Description of NC		Corrective Action Section B			Ammayal	Ammental		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector		
,										





	DESIGN	DRAWN BY	DART AERO	
)	CHECKED	APPROVED	DRAWING NO.	NTARIO, CANADA REV. A
	#	4	D3182	SHEET 1 OF 1
	DATE		TITLE	SCALE
	03.01.21		HINGE	1:1
	A	03.01.21	NEW ISSUE	





D3182-1 HINGE

- 1) MACHINE D3182-1 PER DART DWG "D3182-1.DWG"
- 2) MATERIAL: AISI 304/316 SS SHEET 0.125 THICK (REF DART SPEC. M304S11GA)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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W/O:			WC	RK ORDER CHANGE	S				
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				·					
						_0			
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A :	_ Date: _	
	Res	solution:	Disposition	າ:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	ER NON-CONFORMAN	ICE (NC	₹)			
DATE	STEP Description of NC Section A		Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Section B tion Sign & Date				Approval QC Inspector